

Work Order ID 78921-1

January-17-12 9:01:40 AM

78921

Page 1

Item ID: D3394-043

Revision ID:

Item Name: Lug Assembly

Start Date: 17/01/2012 Start Qty: 80.00

Required Date: 24/01/2012 Req'd Qty: 80.00

Reference:

Approvals: Process Plan: M.L.O

QC:

Date: 12/01/17

Date:

Tooling:

SPC (Y/N):

Date:

Date:

N9000040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3394 DEO

Rev B

100

0.00

100

BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut Blank to .850"

cut @ meter

120

0.00

120

HAAS 1 punch
HAAS CNC vertical machine #1

Memo

MILL AS PER DWG AND FOLIO FA808

FOLIO REV:

DWG REV:

0.00

DEBURR

P/O: 15923

issue P/O to meter

machine is per day D3394 REV.B

CY 12/01/18

CY 12/01/18 80

Work Order ID 78921

January-17-12 9:01:40 AM

78921

Page 2

Item ID: D3394-043

Accept

N9000040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Lug Assembly

Start Date: 17/01/2012 Start Qty: 80.00

80

Cust Item ID:

Required Date: 24/01/2012 Req'd Qty: 80.00

80

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130 *work*

QC2= Inspect parts off machine F/AI/PAIB

0.00

130

QC

Memo

0.00

Quality Control

*work + inspect for transit damage.
attached R of C to W/O*

10/14/12 (17)

135

QC2 Inspect parts - second check

0.00

135

QC

Memo

0.00

Quality Control

8/12/12

(17)

140

Chemical Conversion Coat per QSI005 4.1

0.00

140

HandFinish

Memo

0.00

Hand Finishing

17 BL 12-2-9

Work Order ID 78921

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Item ID: D3394-043

Revision ID:

Item Name: Lug Assembly

Start Date: 17/01/2012 Start Qty: 80.00

Required Date: 24/01/2012 Req'd Qty: 80.00

Reference:

Accept

N900040100

Setup Start ***NS1***

Stop ***NS2***

Cust Item ID:

Customer:

Approvals: Process Plan:

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start ***NR1***

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

150

White Gloss(Ref:4.3.5.1) per QS1005 4.3-Alum

0.00

150

Powdercoat

Powder Coating

Memo

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

0.00

2:30

17.XP M-L 12/02/09

160

QC3- Inspect Part Finish

0.00

160

QC

Quality Control

Memo

0.00

17.XP M-L 12/02/09

170

Small Fab

0.00

170

Small Fab

Small Fab

Memo

Assemble as per Dwg D3394

0.00

EP 12/02/10 (17X)

Work Order ID 78921

January-17-12 9:01:40 AM

78921

Page 4

Item ID: D3394-043

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Lug Assembly

Stop ***NS2***

Start Date: 17/01/2012 Start Qty: 80.00

80

Cust Item ID:

Required Date: 24/01/2012 Req'd Qty: 80.00

80

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

QC5- Inspect part completeness to step on W/O

0.00

180

QC

Memo

0.00

Quality Control

SB 12/02/10

(17)

190

Identify as per dwg & Stock Location: ST 479 0.00

190

Packaging

Memo

0.00

Packaging

(17x) SP12-02-10

200

QC21- Final Inspection - Work Order Release

0.00

200

QC

Memo

0.00

Quality Control

12/2/13 DJ

12/2-02-10
(17)

Picklist Print

January-17-12 9:01:44 AM

Page 1

Work Order ID: 78921

78921

Parent Item: D3394-043

D3394-043

Parent Item Name: Lug Assembly

Start Date: 17/01/2012

Required Date: 24/01/2012

Start Qty: 80.00

Required Qty: 80.00

Comments: IPP Rev: A New Issue 06-01-06 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

MS35489-93

Purchased

No

100

Each

75.0000

2

160

MS35489-93

GROMMET

**

Location

Loc Qty

Loc Code

ST296

75

116235

75

D2423

Manufactured

No

110

f

401.5000

0.07

5.894737

D2423

Lug Extrusion

**

Location

Loc Qty

Loc Code

MAT006

401.5

43722

161.5

45800

1

68331

239

D3394-3P

Purchased

No

170

Each

0.0000

1

80

D3394-3P

Lug

**

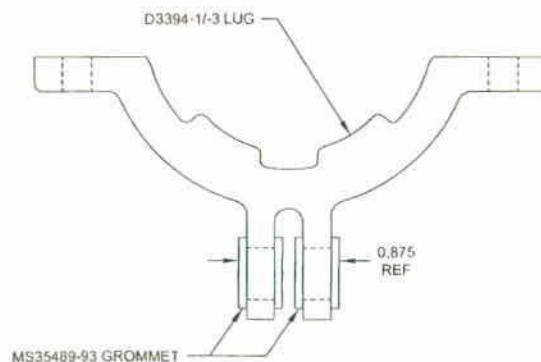
12/02/10
24x
1120422

CL 12/01/18

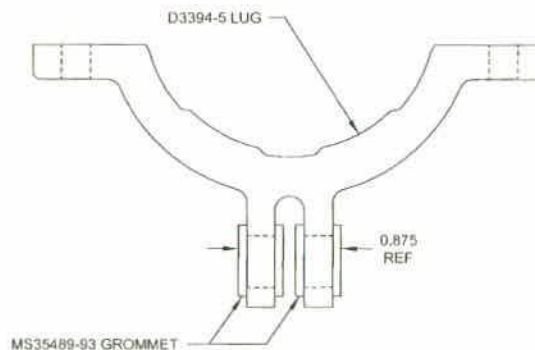
5.90

12/4/8(12)

QTY. -041	QTY. -043	QTY. -045	PART NUMBER	DESCRIPTION
X			D3394-041	LUG ASSEMBLY
	X		D3394-043	LUG ASSEMBLY
		X	D3394-045	LUG ASSEMBLY
1			D3394-1	LUG
	1		D3394-3	LUG
		1	D3394-5	LUG
2	2	2	MS35489-93	GROMMET



D3394-041/-043 LUG ASSEMBLY



D3394-045 LUG ASSEMBLY

DEO ATTACHED

RELEASED
69/06/25 MD

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.20 lbs APPROX

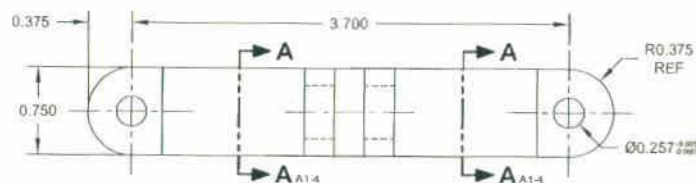
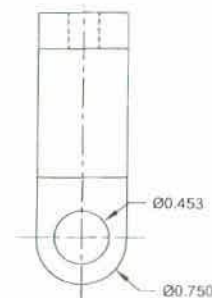
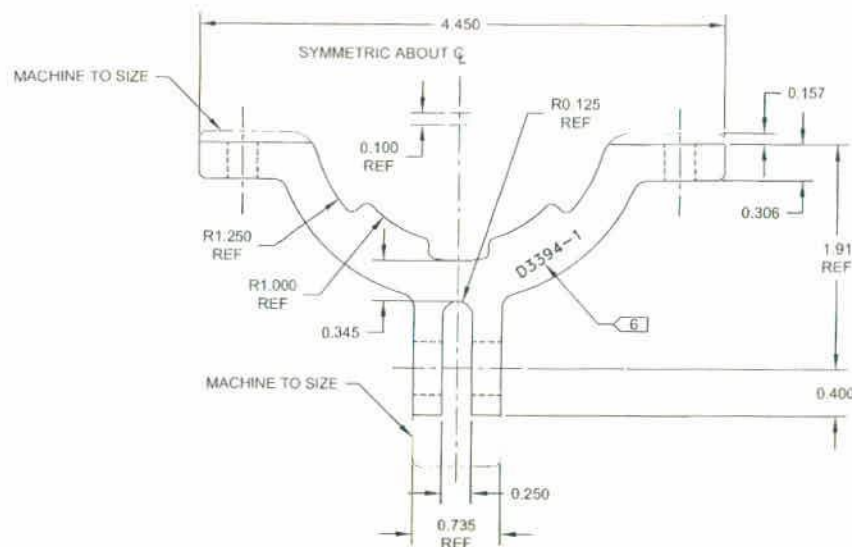
B	ADDED -045, SHT 4 ADDED FILLETS IN SECTION A-A SEE PAR 152	AJS	09.04.02
A	NEW ISSUE	PH	05.02.14
REV.	DESCRIPTION	BY	DATE
DESIGN	PH		
DRAWN	AJS		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.04.02		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3394
TITLE LUG
REV. B
SHEET 1 OF 4
SCALE NTS

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78921



D3394-1 LUG

DEO ATTACHED

RELEASED
09/06/2002

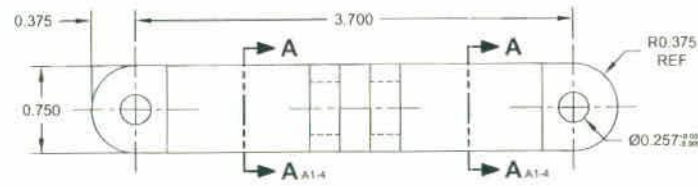
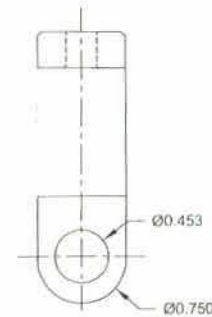
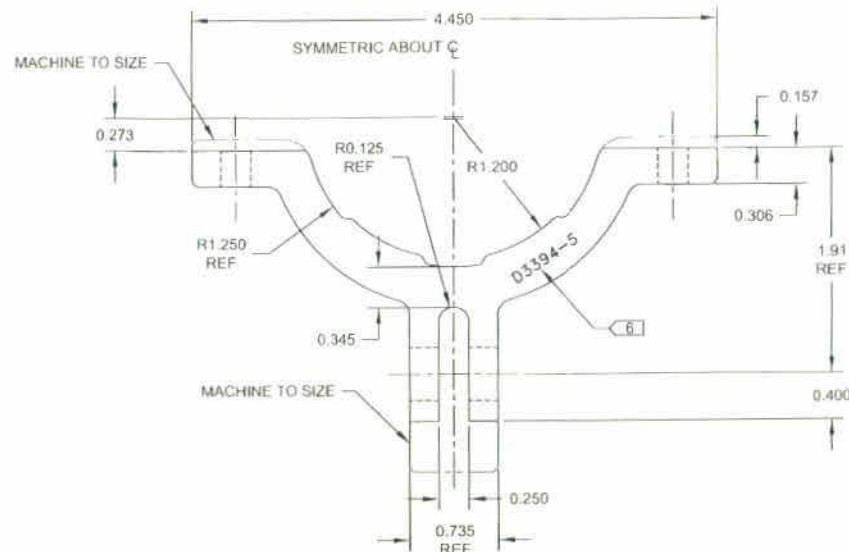
NOTES:

- 1) MATERIAL: MAKE FROM D2423
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO DEPTH OF 0.010±0.005 IN THIS LOCATION,
WITH TOOL A TIP RADIUS OF 0.015±0.005
- 7) WEIGHT: 0.18 lbs

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	A.S.	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG APPR		D3394	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR		LUG	NTS
DATE	09.04.02	COPYRIGHT © 2005 BY DART AEROSPACE LTD	

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	AS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3394	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		LUG	NTS
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78921



D3394-5 LUG

SECTION A-A

DEO ATTACHED

RELEASED

09/04/25

85-2
84-2
85-3
84-3
85-4
84-4

NOTES:

- 1) MATERIAL: MAKE FROM D2423
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO DEPTH OF 0.010 ±0.005 IN THIS LOCATION.
WITH TOOL A TIP RADIUS OF 0.015 ±0.005
- 7) WEIGHT: 0.18 lbs

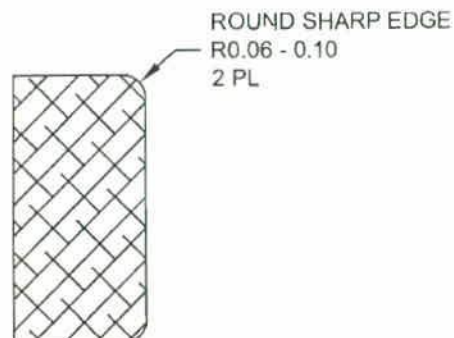
DESIGN	PH	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3394	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		LUG	NTS
DATE	09.04.02	COPYRIGHT © 2005 BY DART AEROSPACE LTD	

489121

DRAWING NO. D3394	TITLE LUG	REV. B	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D3394-B-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN AJS	CHECKED	MFG. APPR.	APPROVED		DE APPR.		
DATE 09.11.04	DATE 09.11.04	DATE 09.11.04	DATE 09.11.04		DATE 09.11.04		

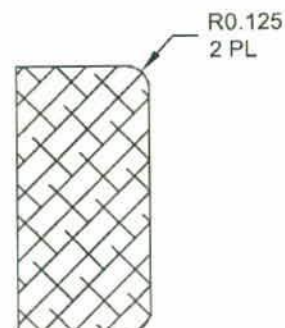
SHEET 4 ZONE A,1 MODIFY SECTION A-A AS SHOWN:

IS:



SECTION A-A

WAS:



SECTION A-A

RELEASED
2009-11-25

REASON: DRAFTING ERROR

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78921

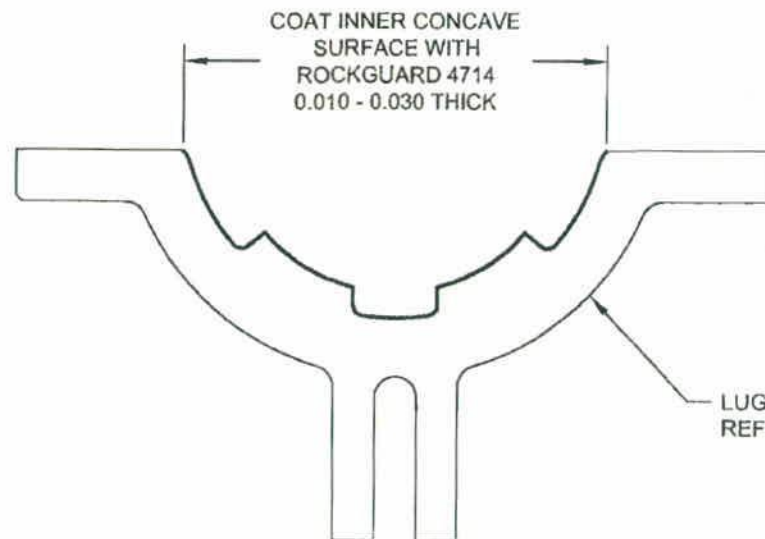
DRAWING NO. D3394	TITLE LUG	REV. B	DART AEROSPACE USA, INC ENGINEERING ORDER		D.E.O. NO. D3394-B-2	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN [Signature]	CHECKED [Signature]	MFG. APPR. [Signature]	APPROVED [Signature]		DE APPR. [Signature]		
DATE 11.05.02	DATE 11.05.09	DATE 11.05.09	DATE 11.05.09		DATE 11.05.09		

PURPOSE

ADD D3394-xRG OPTION

CHANGE

D3394-xRG MOUNTING LUGS ARE INDENTICAL TO D3394-x MOUNTING LUGS, HOWEVER AFTER FINISH, COAT INNER CONCAVE SURFACE WITH "PLUS ONE ROCKGUARD 4714" AS SHOWN BELOW.



D3394-1RG LUG (SHOWN)
D3394-3RG/-5RG LUGS (SIMILAR)
D3394-041RG/-043RG/-045RG LUG ASSEMBLIES (SIMILAR)

RELEASED
2011-05-26
[Signature]



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO15923

Purchase Order Date 1/18/12

PO Print Date 1/18/12

Page Number 1 of 1

Order From :

VC-MET003

METEC METAL TECHNOLOGY INC.
20 TERRY FOX DRIVE PO BOX 781
VANKLEEK HILL, ON K0B 1R0
CA

Contact Name

Vendor Phone

613 678 3957

Vendor Fax

613 678 3956

Vendor Account Nbr

Buyer

Chantal Lavoie

Requisition Nbr

Tax Resale Nbr

10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

CL-2 10/18
ce-hub

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D3394-3P	Lug	1/31/12 Yes	80.00 Each	Dart Truck <i>Net 17</i>	\$18.9500	\$1,516.00
Special Inst:			AS PER DWG D 3394 REV. B B78921				
2	D2731-7P	LUG	1/31/12 Yes	80.00 Each	Dart Truck	\$16.6500	\$1,332.00
Special Inst:			AS PER DWG D2731 REV. C B78922				

PO Total:

\$2,848.00



CL

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable

Change Nbr: 1

Change Date: 1/18/12



20 Terry Fox Drive
Vankleek Hill, Ontario K0B 1R0 , Canada
Tel: (613) 678-3957
Fax: (613) 678-3956

Delivery Slip No.: 18428

Date: Feb 08, 2012

Page: 1

Sold to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Ship to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
Order No.: 15923	Sold By: Dewar, Eric
Shipped By: your truck	Ship Date:

Description	Unit	Ordered quantity	Shipped quantity	Backorder quantity
D3394-3 Lug as per drawing D 3394 REV.B B78921	Each	80	17	63
D2731-7 LUG as per drawing D2731 REV.C B78922	Each	80		80
The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.				
Received by _____		Thank you for your order!		



20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0

Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 metec@metec.ca

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
17	D3394-3	Lug	15923

8/12/02/09

MATERIAL: supplied by DART B68331

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.


Shigi Walz

Vankleek Hill, February 8, 2012